Work Order ID 51301

August 17, 2009 7:32:31 AM

Item ID: D2604-1
Revision ID: B
Item Name: Console Side LH, 407 Console

Accept

Setup Start
Stop

Start Date: 8/17/09 **Start Qty:** 12.00
Required Date: 8/19/09 **Req'd Qty:** 12.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** CL **Date:** 09/08/17 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2604	Rev B								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2604 ☐Dwg Rev: B ☐Prog Rev: B ☐2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

100: 09 08 20 (12)

110: 09 08 20 (12)

120: => 09/08/20 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 51301

August 17, 2009 7:32:31 AM

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
Brake NC	Memo	0.00	SD 09/08/24			12	Ø		
Brake NC	Deburr if necessary□Form as per Dwg D2604								
140	QC5- Inspect part completeness to step on W/O	0.00	=> S 02/08/24			(12)	ϕ		
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00	=> M 09/08/25			X12	ϕ		
HandFinish	Memo	0.00							
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 51301

August 17, 2009 7:32:31 AM

Item ID: D2604-1 **Accept** **Setup Start**

Revision ID: B **Stop**

Item Name: Console Side LH, 407 Console

Start Date: 8/17/09 **Start Qty:** 12.00 **Cust Item ID:**

Required Date: 8/19/09 **Req'd Qty:** 12.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00	BR 09-08-25.			(12).			
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 77	0.00				09/08/26 (12)			
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00				09/08/26			
QC	Memo	0.00							
Quality Control									

09-8-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

August 17, 2009 7:32:31 AM

Work Order ID: 51301

Parent Item: D2604-1RevB

Parent Item Name: Console Side LH, 407 Console

Comments:

Start Date: 8/17/09 **Required Date:** 8/19/09

Start Qty: 12.00 **Required Qty:** 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	292.9416	17.0173			
2024-T3 .040 sheet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	292.9415789	
110337	6.4	
111381	4	
111786	42.5415789	
112291	96	
112331	144	

ml 09 08 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	51301
Description: CONSOLE SIDE LH 407 CONSOLE	Part Number:	D2604-1
Inspection Dwg: Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

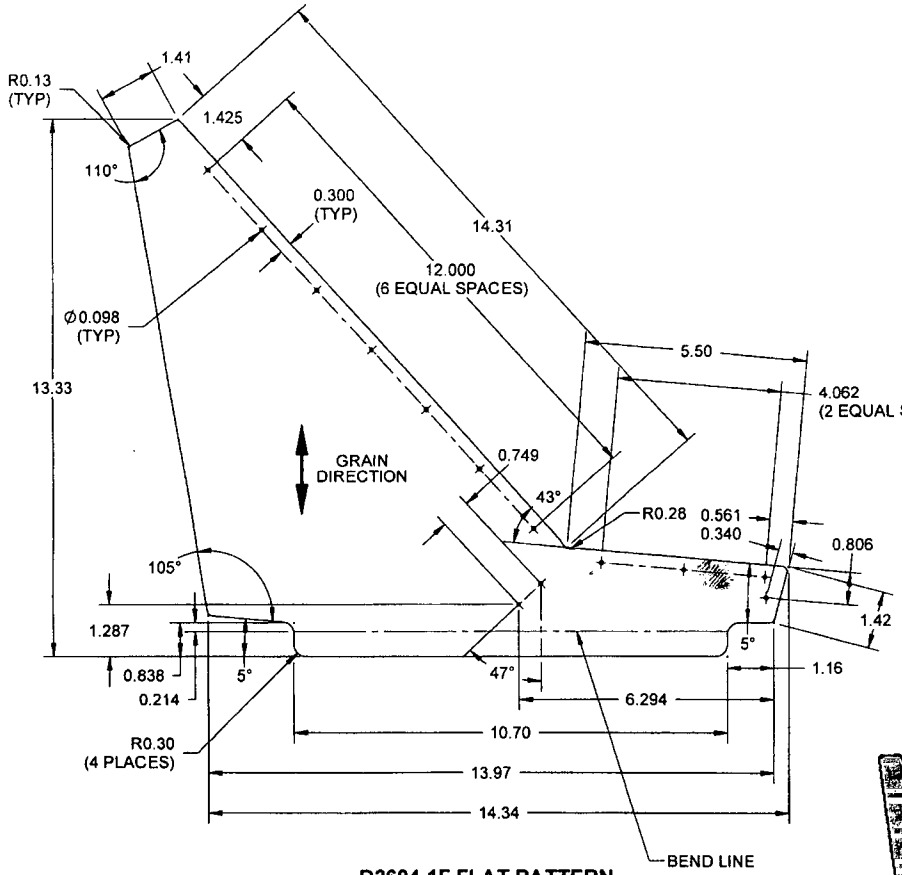
[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+.004 -.001	0.100	✓		VGN	
12.00	+/- .030	12.00	✓		M.T	
10.70	+/- .030	10.70	✓		M.T	
4.067	+/- .010	4.061	✓		VGN	
.749	+/- .010	0.749	✓		VGN	
13.33	+/- .030	13.33	✓		M.T	
14.34	+/- .030	14.34	✓		M.T	

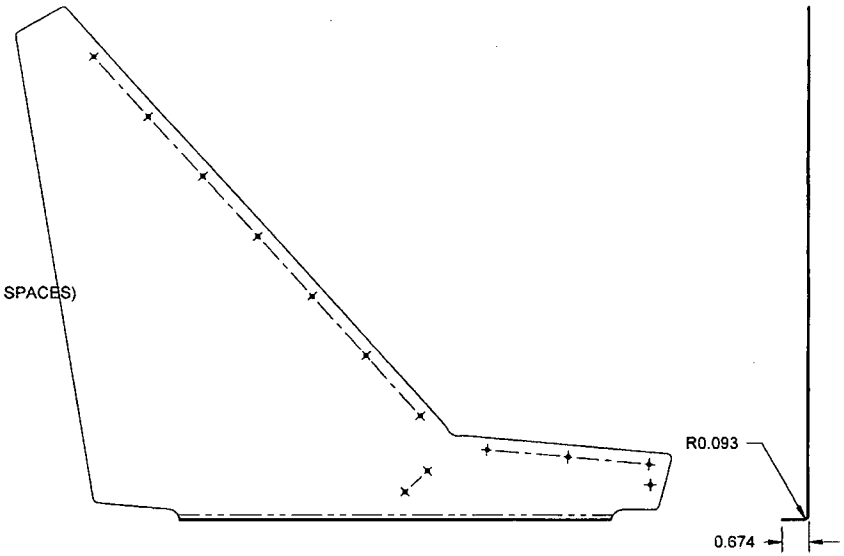
Measured by:	MMM	Audited by:	S	Prototype Approval:	
Date:	9-8-20	Date:	09/08/20	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

CL09/08117
W/O: 51301

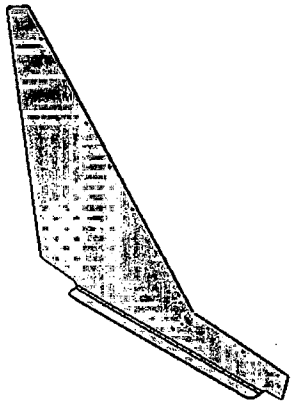


D2604-1F FLAT PATTERN



D2604-1 CONSOLE SIDE (MAKE FROM D2604-1F)
(D2604-2 OPPOSITE)

RELEASED
07.12.12



NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.36 lbs

REV.	DESCRIPTION	BY	DATE
B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2604 WAS D206-547-23/-24	BW	97.10.24

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	BC	
CHECKED		DRAWING NO. D2604 — REV. B — SHEET 1 OF 1
MFG. APPR.		
APPROVED		TITLE: CONSOLE SIDE — SCALE 1:3
DE APPR.		
DATE	07.11.07	